

Date: Tuesday, 4/18/2006 10:06:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 26685		
Estimate Number	: 11336		
P.O. Number	: N/A	Part Number	: D31691
This Issue	: 4/18/2006 S.O. No. : N/A	Drawing Number	: D3169 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25200	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 5/9/2006
Checked & Approved By	: <u>06.04.18</u>	Qty:	12
Comment	: Est Rev:A 02/10/17 New issue KJ	Um:	80 Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0625X02500	6061-T6 Bar .625" x 2.5"
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Comment: Qty.: 0.3360 f(s)/Unit Total : 10.0800 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8 or QQ-A-250/11) (M6061T6B0.625x02.500)
 Batch: M13956

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 3.850" x 2.50" x 0.625" thick

En 06/04/26 x 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA283 and Dwg D3169

2-Deburr & Tumble

J.F. 06/04/27 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/04/27 20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 06.04.27 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 26/05/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST411

SR 06/04/08 @ 20

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SR 06/05/01

6 060501

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

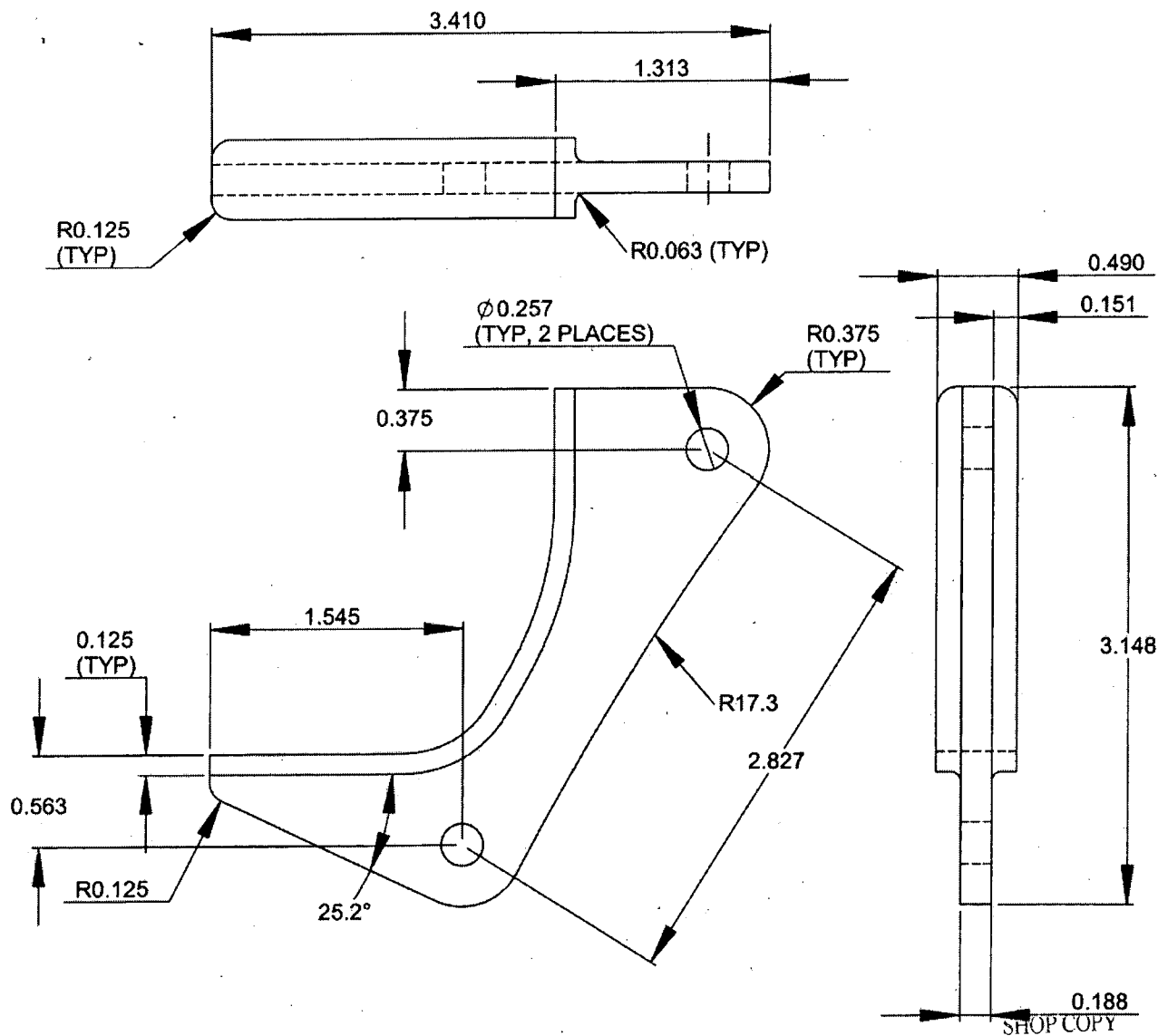
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3169	REV. A SHEET 1 OF 1
DATE 02.09.11	TITLE SUPPORT		SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *CP*



D3169-1 SUPPORT

- 1) MACHINE PER DWG FILE "D3169-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)
(REF DART SPEC M6061T6B OR M6061T6S)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 26685

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